

Work Order ID 118825

118825

Page 1

June-09-14 11:33:03 AM

646.3712

Item ID: 646.3712

B118825

Accept

N900040100

Setup Start

NS1

Revision ID:

REV-A

Stop

NS2

Item Name: Clip

Start Date: 6/13/14

Start Qty: 20.00

*20*10

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3700

A

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut 646.3711 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

115

0.00

115

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24574

CUT PER DRWG

CY 14/06/12 20

DAS
23
9-89

14-08-21

Work Order ID 118825***118825***

Page 2

June-09-14 11:33:03 AM

Item ID: 646.3712

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 6/13/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

Receive & Inspect for Damage & Mat'l Certs

0.00

125

Packaging

Memo

0.00

Packaging

135

QC6- Inspect dimensions to drawing

0.00

135

QC

Memo

0.00

Quality Control

140

Form as per dwg

0.00

140

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

10

DAS
9
9-89DAS
38
9-89

14/8/21

14/08/25

Work Order ID 118825

118825

Page 3

June-09-14 11:33:03 AM

Item ID: 646.3712

Accept

N19000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clip

Start Date: 6/13/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

(10)

DAS
38
9-89

14-8-25

155

0.00

155

HandFinish

Memo

0.00

Hand Finishing

CLEAN AND REMOVE ALL MARKINGS

160

Outsource process-Anodize per QSI017 4.1.10.1

0.00

160

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG : 25574

1- Black Anodize as per Dwg 646.3700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

amg 14/8/29

Work Order ID 118825***118825***

Page 4

June-09-14 11:33:03 AM

Item ID: 646.3712

Accept

N19000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clip

Start Date: 6/13/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Receive & Inspect for Damage & Mat'l Certs

0.00

170

Packaging

Memo

0.00

Packaging

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: 800CK103

0.00

210

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

14/9/8 (10)

10

DAS
38
9-89

1498

10X 801498

Work Order ID 118825

118825

Page 5

June-09-14 11:33:03 AM

Item ID: 646.3712

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clip

Start Date: 6/13/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 14-09-09

MF
14-9-8

Picklist Print

June-09-14 11:33:03 AM

Work Order ID: 118825

118825

Parent Item: 646.3712

646.3712

Parent Item Name: Clip

Start Date: 6/13/14

Required Date: 6/13/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.11.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	503.0880	0.036	1			
M6061T6S 063									**	<u>C214/06/27</u>			
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

84.768

M128941

284

m129637

①

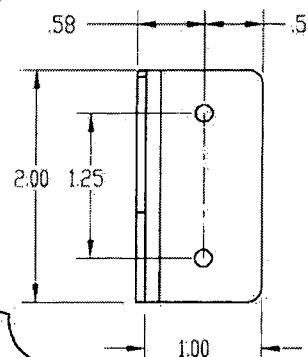
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

△ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

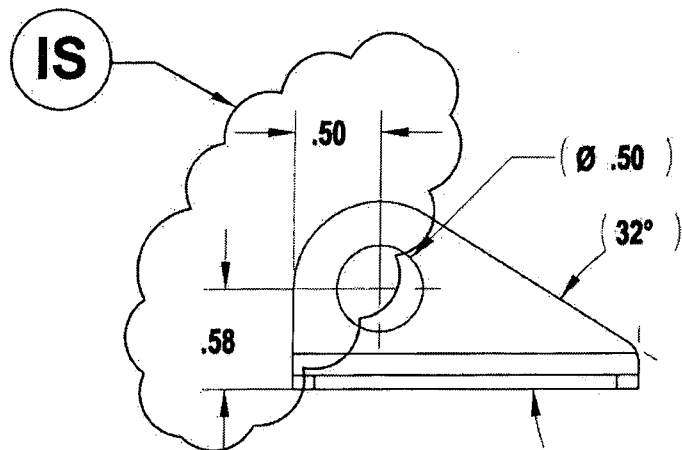
IS



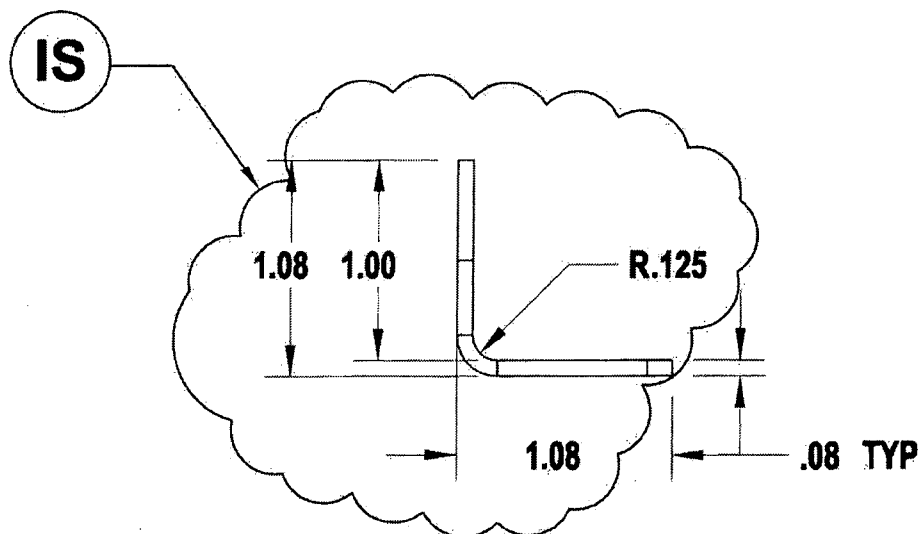
118825 MJS
14-05-06

SHEET 7, ZONE B1 IS:

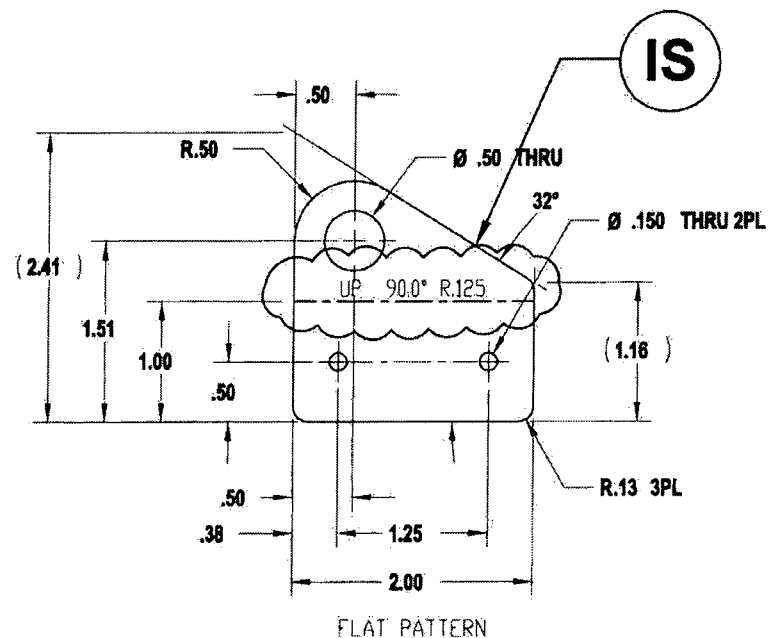
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BDM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

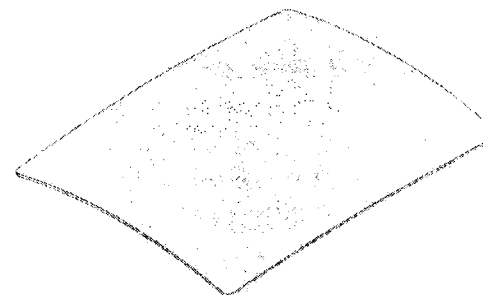
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
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REVISION			
REV.	DESCRIPTION	DATE	APPROVED
1	UNINCORPORATED ECN 03702		TS

NOTES:

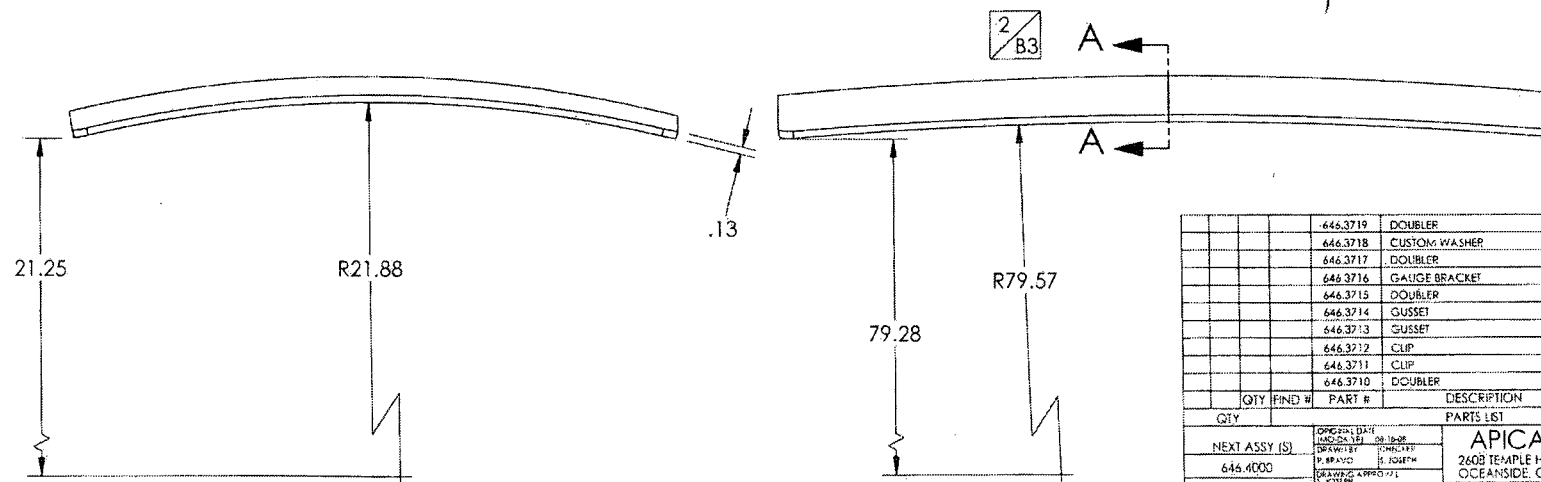
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

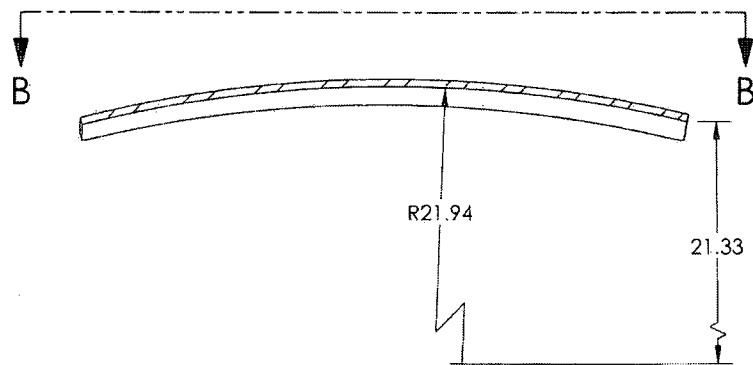
UNINCORPORATED ECN(s)

03702



			646.3719	DOUBLER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

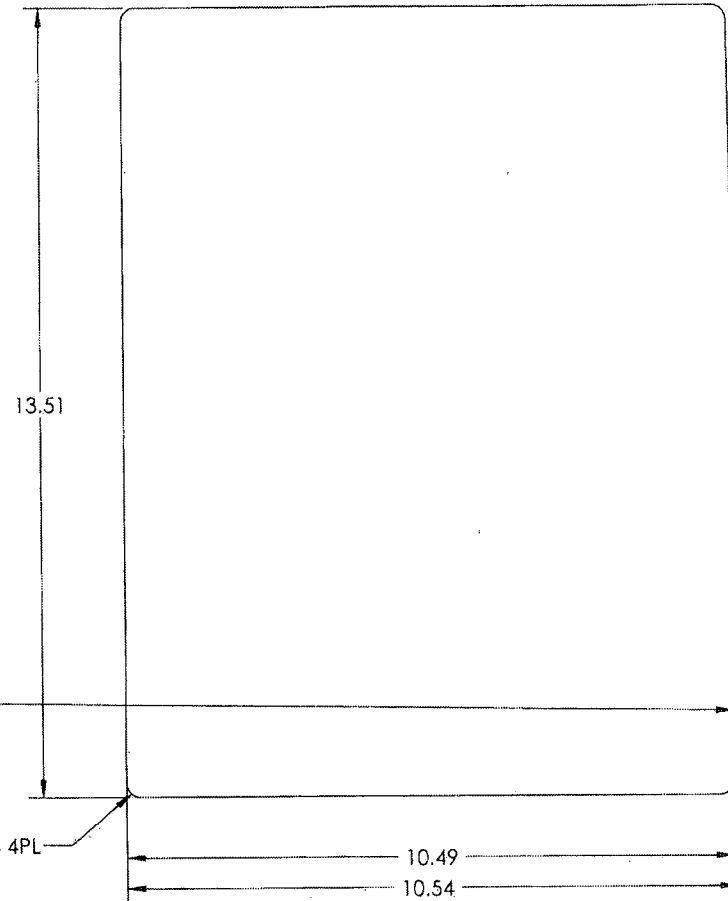


SECTION A-A



R395.138

R.13 4PL



SECTION B-B

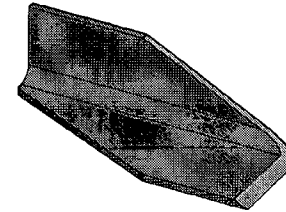
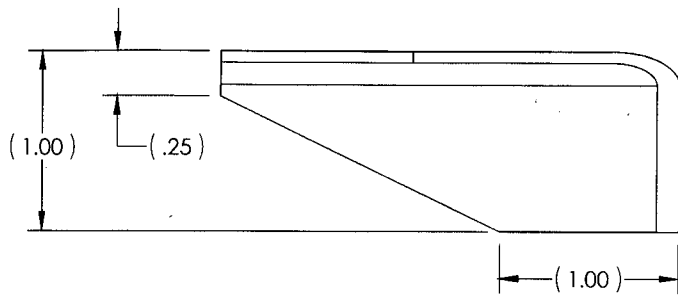
DATE: 06/10/08
DRAWN BY: J. SCHULTZ
P. SKAYO
DRAWING APPROVAL
S. J. SCHULTZ
CONTRACT NO.
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
DECIMALS ARE:
1 PLACE DECIMALS ± .01
2 PLACE DECIMALS ± .005
ANGLES ± .5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300
SHEETMETAL
SHEET CODE: B 07M16 DWS NO: 646.3700 REV: A
SCALE: NONE SHEET 2 OF 9

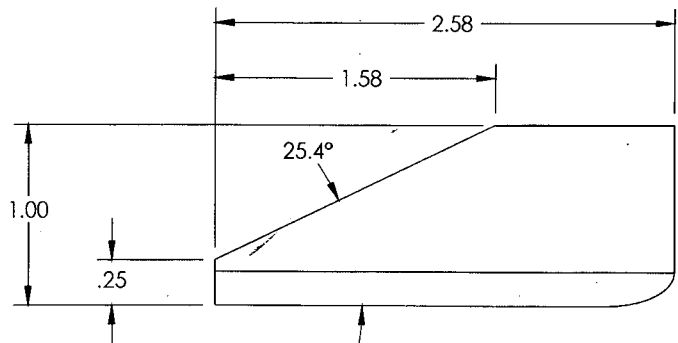
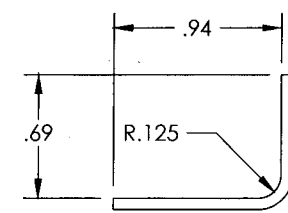
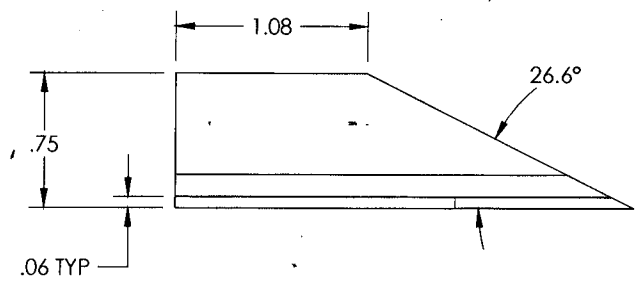
DFX

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



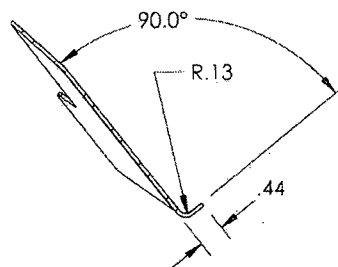
646.3711 SHOWN
646.3712 OPPOSITE



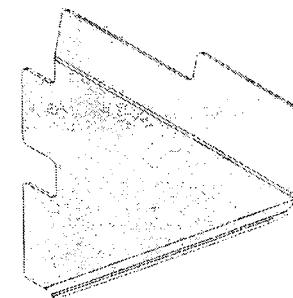
NEXT ASSY (S)		ORIGINAL DATE (DD-MM-YY)	08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY P. BRAVO		CHECKED S. JOSEPH			
DRAWING APPROVAL S. JOSEPH		DATE 08-18-08		SHEETMETAL	
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET CODE B	07MZ6	DWG. NO. 646.3700	REV. A
		SCALE: NONE		SHEET 3 OF 9	

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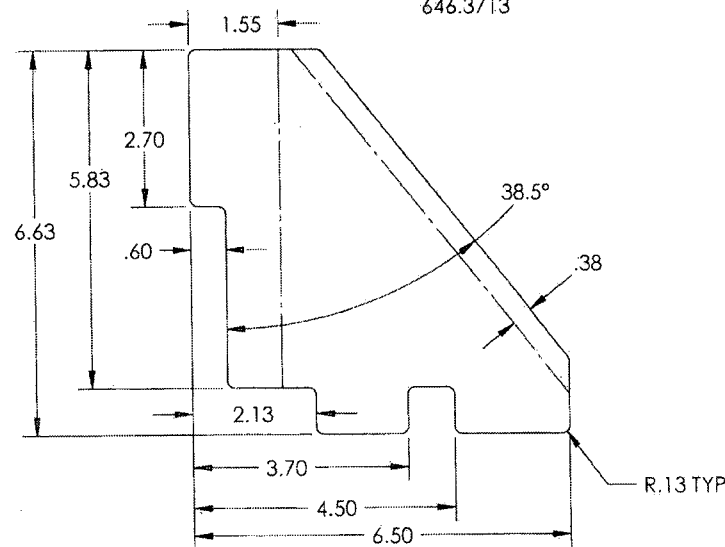
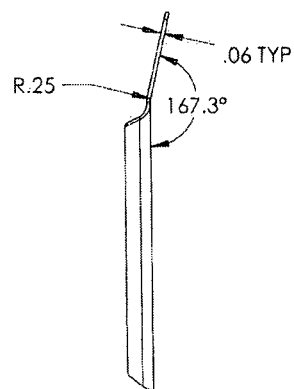
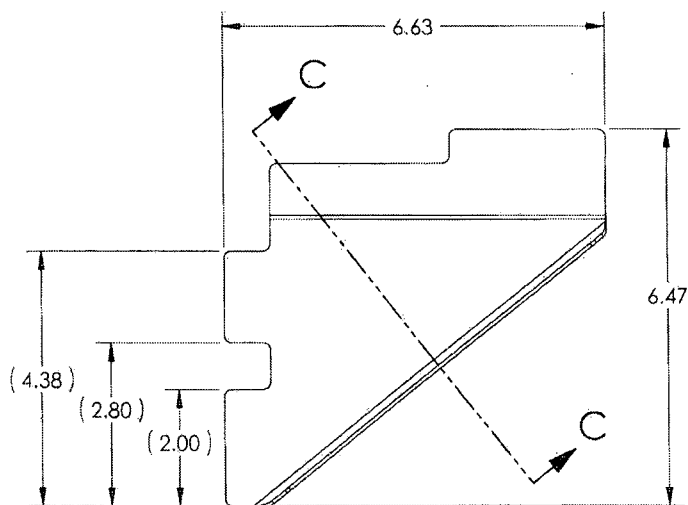
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713

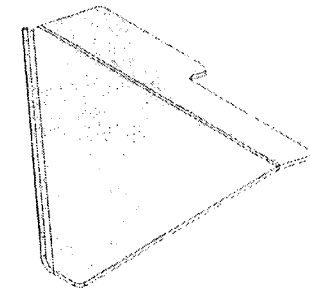
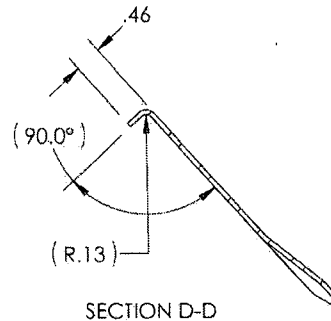
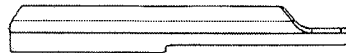


FLAT PATTERN

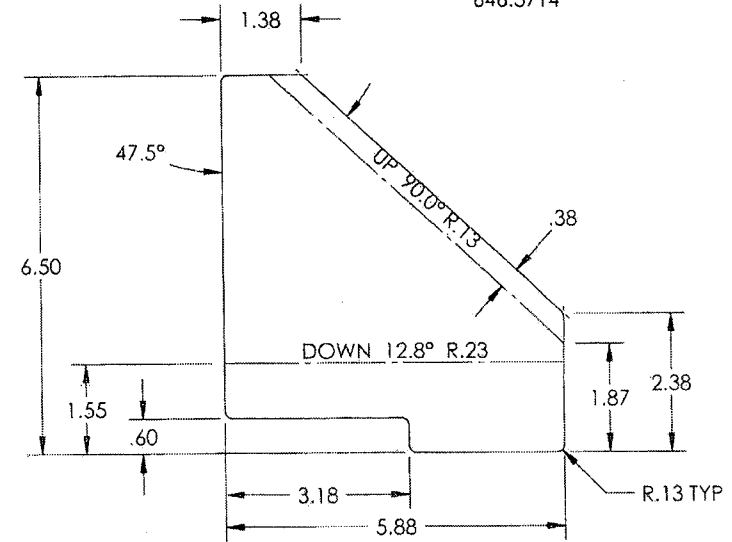
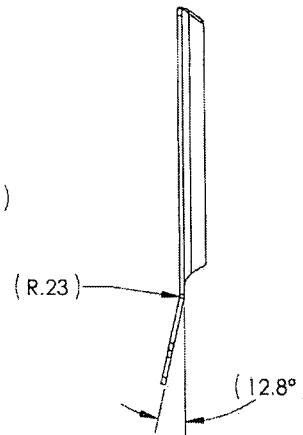
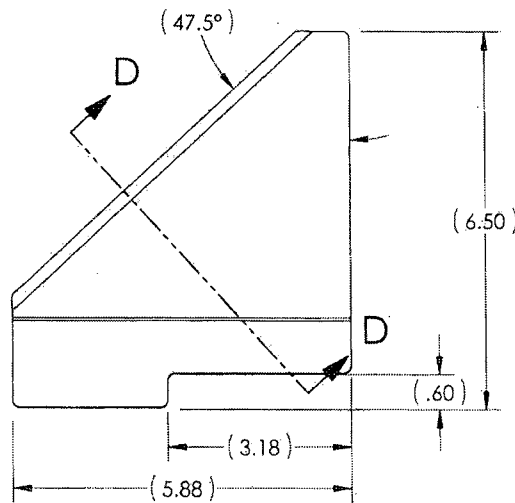
NEXT ASSY. [S]	ORIGINAL DATE:	08-18-06	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
	DESIGNED BY:	J. JOSEPH	
	CHECKED BY:	J. JOSEPH	
	DRAWN BY:	J. JOSEPH	
	DATE:	08-18-06	
	LARGEST DIMENSION MEASURED		SHEETMETAL
	DIMENSIONS ARE IN INCHES		
	TOLERANCES ARE:		
	2 DECIMAL PLACES ± .01		
	3 DECIMAL PLACES ± .005		
	ANGLES ± .5°		SHEET # OF 9
	SCALE: 1"=1"		

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REV.	DESCRIPTION	DATE	APPROVAL



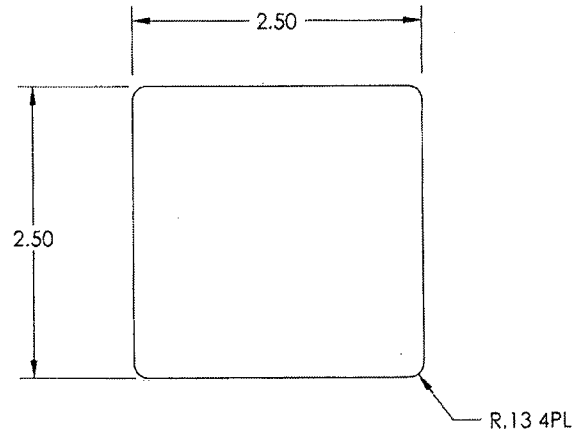
646.3714



ORIGINAL DATE 8/18/08 DRAWN BY J. K. G. / C. K. G. / P. B. A. / V. O. CHECKED J. K. G. / C. K. G. / P. B. A. / V. O. DRAWING APPROVAL J. K. G. / C. K. G. / P. B. A. / V. O. CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACES DECIMALS ± .01 ANGLES ± .5°	SHEETMETAL		
SEE: B	CAGE CODE: 07M76	DWG. NO: 646.3700	REV: A
SCALE: NONE	SHEET: 5 OF 9		

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

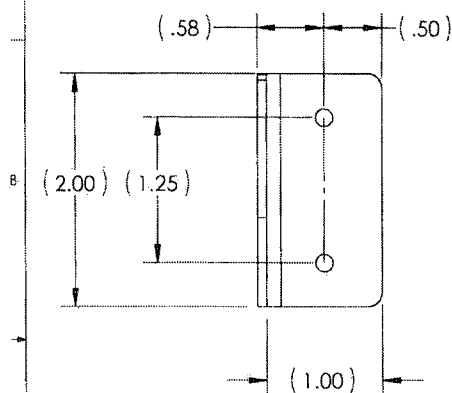


646.3715

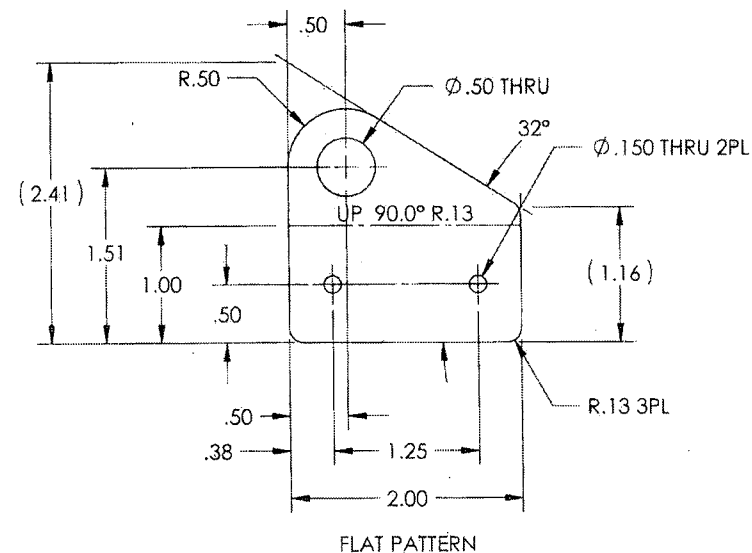
NEXT ASSY (S)		ORIGINAL DATE 08-18-08 (DRAWING NO.)	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
		DRAWN BY P. BRAYO		
		CHECKED BY J. JOHNSON		
		DRAWING APPROVED BY J. JOHNSON		
		DATE 08-18-08	SHEETMETAL	
		CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED:		UNIT CASH CODE	ENG. NO.	REV
TOLERANCES: .001		B	07M16	A
2 PLACE DECIMALS .001		SCALE: NONE	646.3700	
3 PLACE DECIMALS .000				
ANGLES: 1:5				

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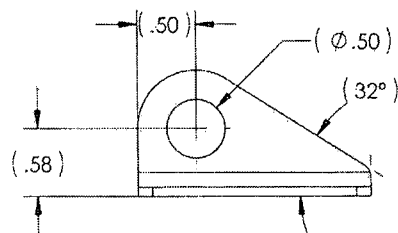
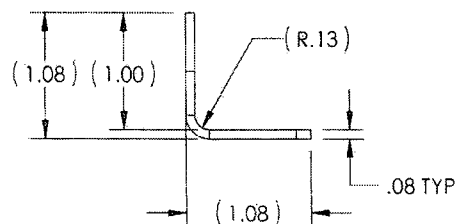
REVISIONS		
REV.	DESCRIPTION	DATE



646.3716



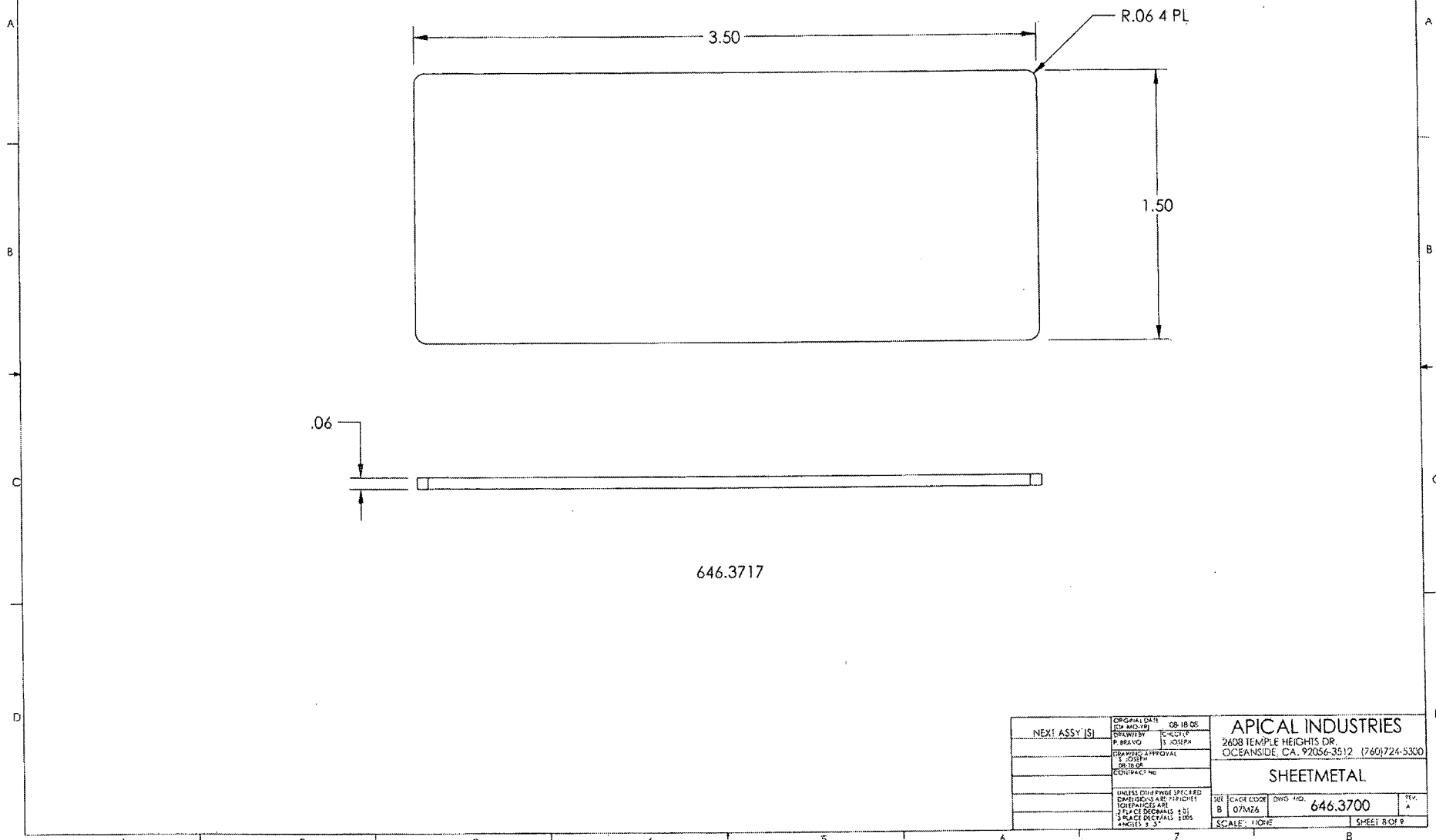
FLAT PATTERN



NEXT ASSY (S)	ORIGINAL DATE	06-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	DRAWN BY	W. JOSEPH		
	CHECKED BY	W. JOSEPH		
	DATE	06-18-08		
	SHEET METAL			
WHEN OTHERWISE SPECIFIED			SHEETMETAL 646.3700	
DIMENSIONS ARE IN INCHES				
TOLERANCES ARE				
2 PLACE DECIMALS ± .01				
FRACTIONS ± .005				
ANGLES ± 5°			SCALE: 1/4"=1"	
			SHEET 7 OF 9	

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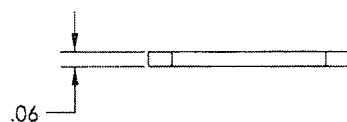
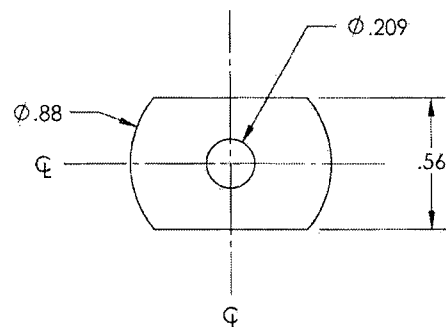
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



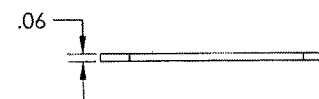
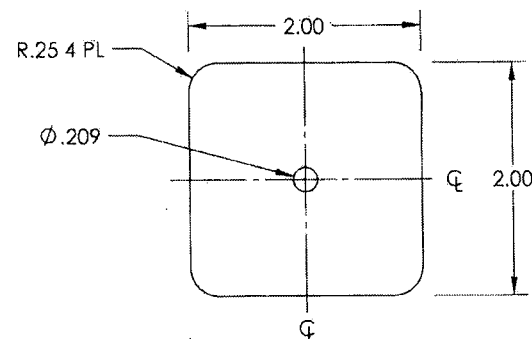
NEXT ASSY [S]	ORIGINAL DATE	08-18-05	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	BY (MFG)			
	DESIGNED BY		SHEETMETAL	
	DESIGNED BY			
	DESIGNED BY		646.3700	
	DESIGNED BY			
UNLESS OTHERWISE SPECIFIED			SCALE: 1:100	SHEET 8 OF 9
DIMENSIONS ARE IN INCHES				
3 PLACE DECIMALS (0.001)				
ANGLES 2.5°				

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REV.	DESCRIPTION	DATE	APPROVED



646.3718



646.3719

NEXT ASSY (S)	ORIGINAL DATE 10-10-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
	DESIGNED BY P. BRAVO		
	CHECKED BY S. JOSEPH	SHEETMETAL	
	DRAWING APPROVAL S. JOSEPH 08-10-08		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMAL: .005 3 PLACE DECIMAL: .001 ANGLES: .1°	SHEET 9 OF 9		

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6192
Date: 2014-07-10
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24574	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-10
Tracking No.:	

Item No.	Unit	Description	Quantity
646.3711	Chaque	646.3711 clip	40
646.3712	Chaque	646.3712 clip	20
646.3712	Chaque	646.3712 clip	40
646.3713	Chaque	646.3713 gusset	40
646.3714	Chaque	646.3714 gusset	40
646.3717	Chaque	646.3717 doubler	30
646.3719	Chaque	646.3719 doubler	20
646.3719	Chaque	646.3719 doubler	40
d2365	Chaque	d2365 wearplate pin	30
d3283-1	Chaque	d3283-1 doubler	40
d3208-3	Chaque	d3208-3 pedal mount angle	20
d3290-1	Chaque	d3290-1 frame	30
d3302-1	Chaque	d3302-1 doubler	10
d3302-3	Chaque	d3302-3 doubler	10
d3363-1	Chaque	d3363-1 console	16
d4072-3	Chaque	d4072-3 airframe hinge backing plate	40
d4073-3	Chaque	d4073-3 door hinge backing plate	50
d4074-5	Chaque	d4074-5 backing plate	40
d4610-5	Chaque	d4610-5 shim	20

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25574

Purchase Order Date 8/29/2014

PO Print Date 9/3/2014

Page Number 1 of 5

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED
\$

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Michael Gregoire

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	120626	646.3711 Clip	9/8/2014 No 9/8/2014		49.00	\$6.10	\$298.90
Parts to be anodized and primed as per Drawing 646.3711 Rev.A							
Finish: Hard anodize IAW MIL-A-8625 Type 3, Class 2, Color Black							
Prime: Cardinal 4860-50 Pretreatment Primer IAW MIL-P-23377J Type 1 Class N							
Line Total:							\$298.90
2	118825	646.3712 Clip	9/8/2014 No 9/8/2014		10.00	\$6.10	\$61.00
per Drawing 646.3712 Rev.A							
Finish: Hard anodize IAW MIL-A-8625 Type 3, Class 2, Color Black							
Prime: Cardinal 4860-50 Pretreatment Primer IAW MIL-P-23377J Type 1 Class N							
Line Total:							\$61.00

Note:

9/3/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63243

Date: 08-Sep-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
49 ea	Part: 646.3711 CLIP HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140567	Rev:	PO: PO25574 Line:
10 ea	Part: 646.3712 CLIP HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140568	Rev:	PO: PO25574 Line:
40 ea	Part: 646.3712 CLIP HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140569	Rev:	PO: PO25574 Line:
40 ea	Part: 646.3713 GUSSET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140570	Rev:	PO: PO25574 Line:
40 ea	Part: 646.3714 GUSSET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N	Rev:	